

# Work Order ID 117573

April-28-14 8:08:50 AM

**\*117573\***

Page 1

Item ID: D4712-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 4/28/14 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 5/01/14 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 140428 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4712	<u>FCV</u>								
100	FLOW WATER JET <sup>o</sup>	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
<u>6001.020</u>	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

20 0 Jm14-04-28

20 0 Jm14-04-28

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Required Date: 5/01/14 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 27 9-89 14/4/29				23			
130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg NC BRAKE  Memo C'sink holes as per dwg	0.00 0.00			DAS 30 9-89	23			14/04/29 DAS 36 9-89
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00 DAS 27 9-89 14/4/29				23			

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 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 4/28/14 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 5/01/14 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00				23			
<b>*150*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00				23x			
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>G-A</u>	0.00				23x			
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									

DAS  
36  
9-89

DAS  
36  
9-89

**Work Order ID 117573**

April-28-14 8:08:50 AM

**\*117573\***

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Item ID: D4712-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 4/28/14 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

MLT 14-05-01

LL404.30

# Picklist Print

April-28-14 8:08:50 AM

Page 1

Work Order ID: 117573

**\*117573\***

Parent Item: D4712-3

**\*D4712-3\***

Parent Item Name: Bracket

Start Date: 4/28/14

Required Date: 5/01/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.11.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.050

Purchased

No

100

sf

240.7500

0.182

4

**\*M6061T6S 050\***

**\*\***

Jm14-04-28

6061-T6 .050 Sheet

Location

Loc Qty

Loc Code

MAT

95

M128408

95

MAT021

145.75

123293

31.5

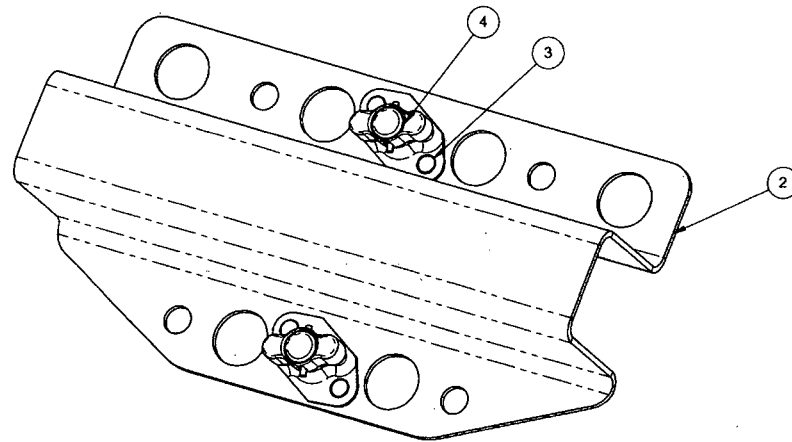
125636

114.25

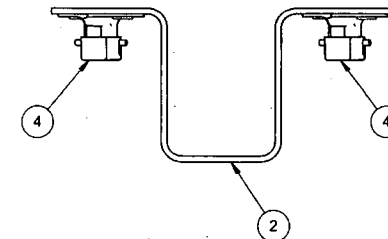
25636



ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4712-043	BRACKET ASSEMBLY
2	1	D4712-3	BRACKET
3	4	MS20426AD3-2	RIVET
4	2	2350-18-C3Y	RIGID RECEPTACLE



**D4712-043 BRACKET ASSEMBLY**



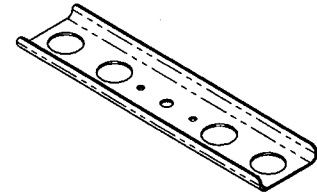
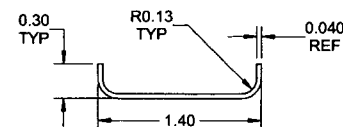
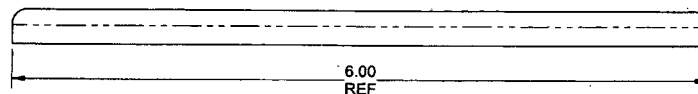
117573 MCO  
140428

**RELEASED**  
2013-12-23  
ASS ECN13-705

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs

C	Ø 0.129 WAS Ø 0.098 (ZN C4-3)	RF	13.09.11
B	REMOVED -Ø41-5; REMOVE CSK ON D4712-1F (ZN D4-3); Ø0.221 WAS Ø0.500 (ZN B4-3); REVISE D4712-3-043 (ZN B4-4, B4-5)	RF	13.06.18
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. C
MFG. APPR.	IS	D4712	SHEET 1 OF 5
APPROVED	IS	TITLE	SCALE
DE APPR.	CA	SUPPORT BRACKET ASSY	NTS
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**D4712-1 BRACKET**

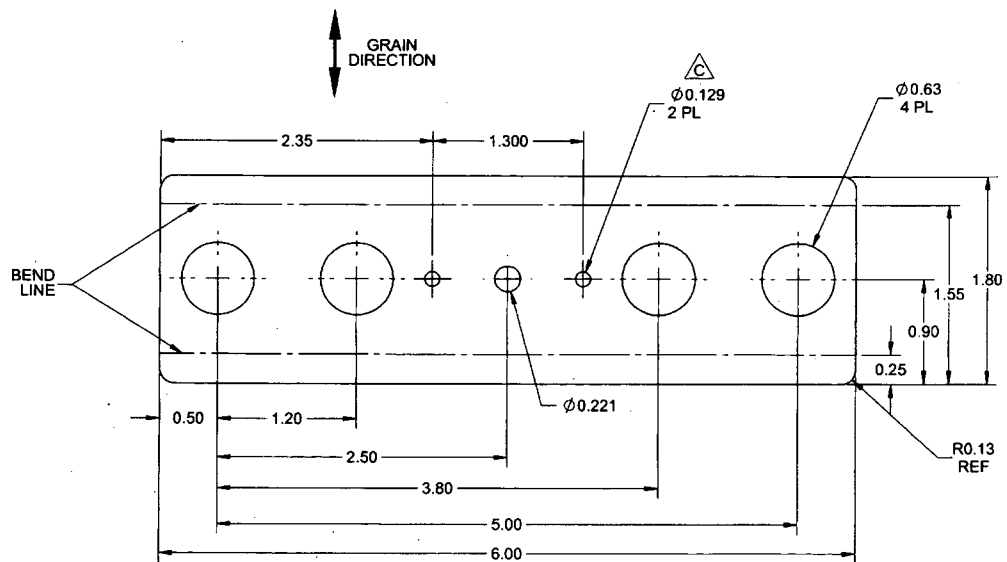
**RELEASED**  
2013-12-23  
A/S

**NOTES:**

- 1) MATERIAL: MAKE FROM D4712-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. C
MFG. APPR.	PC	<b>D4712</b>	SHEET 2 OF 5
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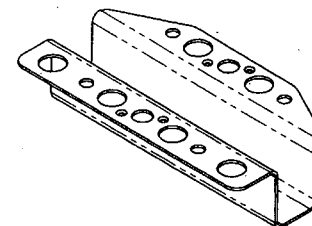
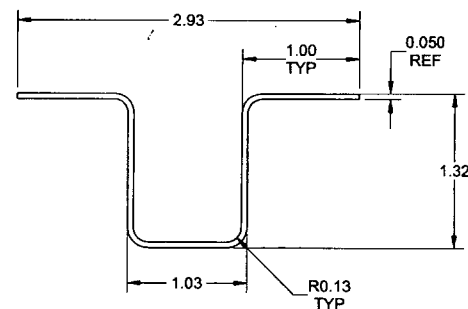
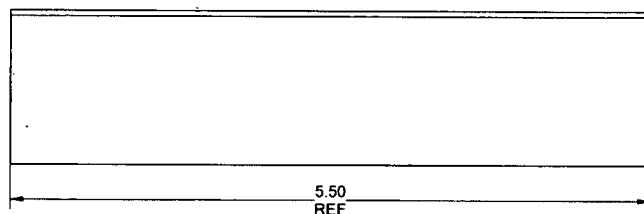
**D4712-1F FLAT PATTERN BRACKET**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

**RELEASED**  
2013-12-23  
ASS

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	DS	D4712	SHEET 3 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	SUPPORT BRACKET ASSY	NTS
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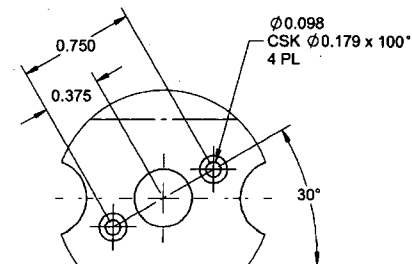
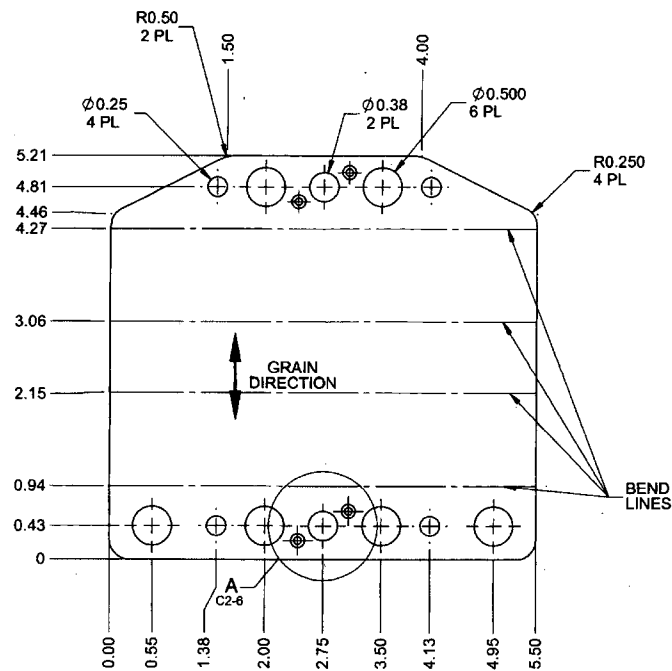
**D4712-3 BRACKET**

**RELEASED**  
2013-12-23  
ASS

**NOTES:**

- 1) MATERIAL: MAKE FROM D4712-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO.	REV. C
MFG. APPR.	DS	D4712	SHEET 4 OF 5
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DETAIL A B6-6  
2 PL D5-6

0.050  
REF

# **D4712-3F FLAT PATTERN BRACKET**

**RELEASED**  
2013-12-23  
ADS

## **NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED	PC	DRAWING NO.	REV. C
MFG. APPR.	DS	<b>D4712</b>	SHEET 5 OF 5
APPROVED	JS	TITLE	SCALE
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